



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3396-1
Job Sheet 175945



Part No: D3396-1

Job Qty: 24 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/12/18

Job Tracking No:

Due Date: 5/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP A 05.02.23 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea		5/19/18	0.00	0.00	Start Up Machining-2		JB - 18.04.21
100	Hardinge	24 pcs		5/21/18	0.00	0.93	Hardinge		JB - 5.21.18
120	QC	24 pcs		5/21/18	0.00	0.00	QC8		
130	Packaging	24 pcs		5/21/18	0.00	0.00	Packaging3-1		APR 24 2018
140	QC21-SA	24 Ea		5/21/18	0.00	0.00	QC21		

Part Op Descriptions: 100 - Turn as per Folio FA514 and Dwg D3396

DAS
21
9-89

APR 24 2018

DAS
6
-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRRN0.750	Delrin Round Bar 0.75" Color: Black	1.5000 ft (.0625 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MDELRRN0.750	2	33	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.226inches $\pm$ 0.010	0.236 0.216		
2	Spacer	0.257inches + 0.005 - 0.000	0.262 0.257		
3	Spacer	0.740inches $\pm$ 0.010	0.750 0.730		
4	Spacer	0.032inches $\pm$ 0.010	0.042 0.022		
5	Spacer	45Degrees $\pm$ 0	45 45		

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description _____	DISPOSITION Rework ☐ Scrap ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td></td> <td></td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
		Supplier ☐																			
		MRB (QSI042) Approval																			
		Completed By																			
		Lead hand / Supervisor Approval Verification																			
		QC / QA Coordinator Approval																			

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DART
AEROSPACE

Container No: S063394
 Part: D3396 - 1
 Job No: 175945
 Serial No/Batch: S063394
 Revision:
 Inspector:

Date: 04/21/18

Root Cause			
Environment ☐	No Re-v ☐		
Design ☐	Operator ☐	Bending ☐	ss/Surge ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	gram ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : ☐	